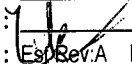


Daks:
User:Thursday, 19/04/2007 1:33:06 PM
Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212S DETAIL PARTS
Job Number	: 31958		
Estimate Number	: 12839		
P.O. Number	: N/A	Part Number	: D2127251925
This Issue	: 19/04/2007 S.O. No. : N/A	Drawing Number	: D212-725-1 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 26/04/2007 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	: Esp Rev A New Issue 07-04-19 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR1000W049 304 RD Tube 1.0" x .049W



Comment: Qty.: 1.9100 f(s)/Unit Total: 1.9100 f(s)

304 RD Tube 1.0" x .049W

BATCH: M103840

2.0 AN81816J Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M104203

3.0 MS2081916J Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Sleeve

Batch: M104203(X1) / M103249(X1)

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D212-725-1 and Template DT8912.

2-Flare ends as per Dwg D212-725-1.

****ENSURE TO INSTALL SLEEVE & NUTS BEFORE FLARING****

FF 07-04-24

Date	STEP	Description of NC	Initial	Action Description	Sign & Date
07-04-20	4	Section A inside bend not smooth (Rible)		Scrap & Destroy make new one	ff 09-07-20

Date: Thursday, 19/04/2007 1:33:06 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212S DETAIL PARTS

Job Number: 31958

Part Number: D2127251925

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2004.24
Inspected per DT8912

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



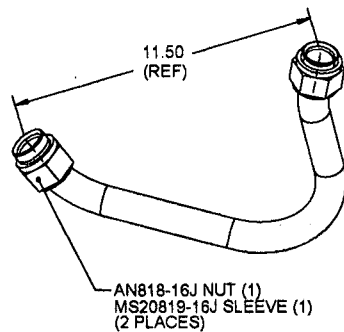
Comment: FINAL INSPECTION/W/O RELEASE

2004.24
2004.24

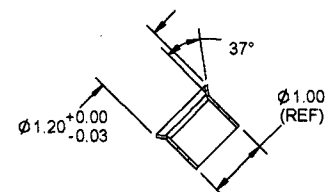
Job Completion



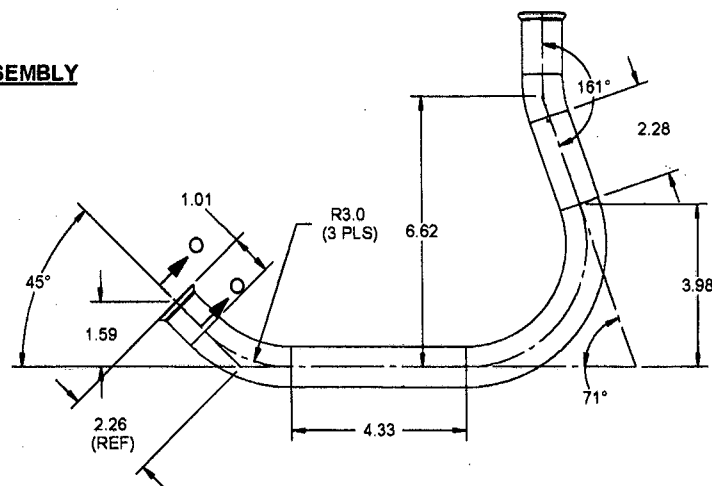
U 070502



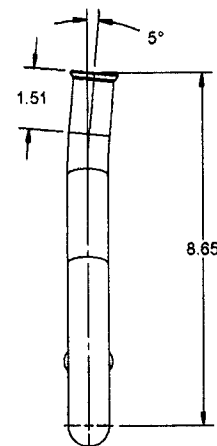
D212-725-1-925 TUBE ASSEMBLY



SECTION O-O
SCALE 1:2
(FINISH FLARE ONE END
AFTER ASSEMBLY)



D212-725-1-131 TUBING
MANUFACTURE PER TEMPLATE DT8912



W/O 3958

NOTES:

- 1) MATERIAL: AISI 304/316 SS $\phi 1.00 \times 0.049$ WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR1.000W.049)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D212-725-1-925 USING FINE POINT PERMANENT INK MARKER

B	07.03.22	ADDED D212-725-1-131
DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED	DRAWING NO. D212-725-1 REV. B SHEET 42 OF 42
DATE 07.03.22	TITLE 212S DETAIL PARTS	SCALE 1:3
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/20	# 4	inside radius not smooth (rippled)	<i>[Signature]</i> 05/04/2	scrap & Destroy make new one <u>modify the hand knurler for pin release smooth bands.</u>	FF 07-04-20 <i>[Signature]</i>	<i>[Signature]</i> 07/04/20	<i>[Signature]</i> 05/04/2	<i>[Signature]</i> 07-04-20

NOTE: Date & initial all entries